

Work Order ID 65639 - 2

January 20, 2011 2:14:58 PM



Page 1

Item ID: D3041-3

Revision ID:

Item Name: Clamp

Start Date: 1/20/11

Required Date: 2/18/11

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Setup Start

Stop

Run Start

Stop

Cust Item ID:

Customer:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3041

Rev C

100

0.00



Bandsaw

BAND SAW

Memo

0.00

Jcaspa Bandsaw

Cut-D2423 Extrusion: 1.250" Long

cut @ meter

110

0.00



HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

4HAAS CNC vertical machine #1

Check for cracks while loading into the machine
Machine as per Folio FA153 and Dwg D3041
DWG REV: _____
FOLIO REV: _____

issue P/O 13326

meter machine as per dwg D3041 REV.C

CX 1/10/21 @20

120

0.00



QC RK
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

check + inspect for transit damage

Pu/3/5 @12

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Page 2

Item ID: D3041-3

Revision ID:

Item Name: Clamp

Start Date: 1/20/11

Required Date: 2/18/11

Reference:

Start Qty: 20.00

Req'd Qty: 20.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



QC

Quality Control

QC Inspect parts - second check

0.00

Memo

0.00

11 53 10 12

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

12 BR 11-3-14

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

Mask inside of 0.8120" diameter hole START TIME: 3:35 OVEN TEMPERATURE: 320° FINISH TIME: 4:05

12 BR 11-3-14

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Item ID: D3041-3

Accept

Revision ID:

Item Name: Clamp

Start Date: 1/20/11 Start Qty: 20.00

Required Date: 2/18/11 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 of 11/03/15

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- Press D2611 bearing into lug as per Dwg D3041 using DT 9472

2- Stake bearing into place as per Dwg D3041 using DT9456

3-Touch up stake marks with white emeron paint

9/5/03/15 (12)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/03/15

(H2)

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Item ID: D3041-3

Revision ID:

Item Name: Clamp

Start Date: 1/20/11 Start Qty: 20.00

Required Date: 2/18/11 Req'd Qty: 20.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: 463

0.00

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

11/3/16 SF 120

11/3/17

CX 11/03/16

Picklist Print

January 20, 2011 2:14:58 PM

Page 1

Work Order ID: 65639-2

Parent Item: D3041-3

Parent Item Name: Clamp



Start Date: 1/20/11

Required Date: 2/18/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: A 01.07.11 New Issue SM/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2423		Manufactured	No			170	f	534.1914	0.1042	2.193684			
-------	--	--------------	----	--	--	-----	---	----------	--------	----------	--	--	--



Lug Extrusion



CL 1/10/12

Location

Loc Qty

Loc Code

MAT06

534.1914265

43722

180

45800

66.1914265

63005

288

D2611

Manufactured No

100

Each

20.0000

20



Bearing



1/21/15

Location

Loc Qty

Loc Code

ST020

20

51262

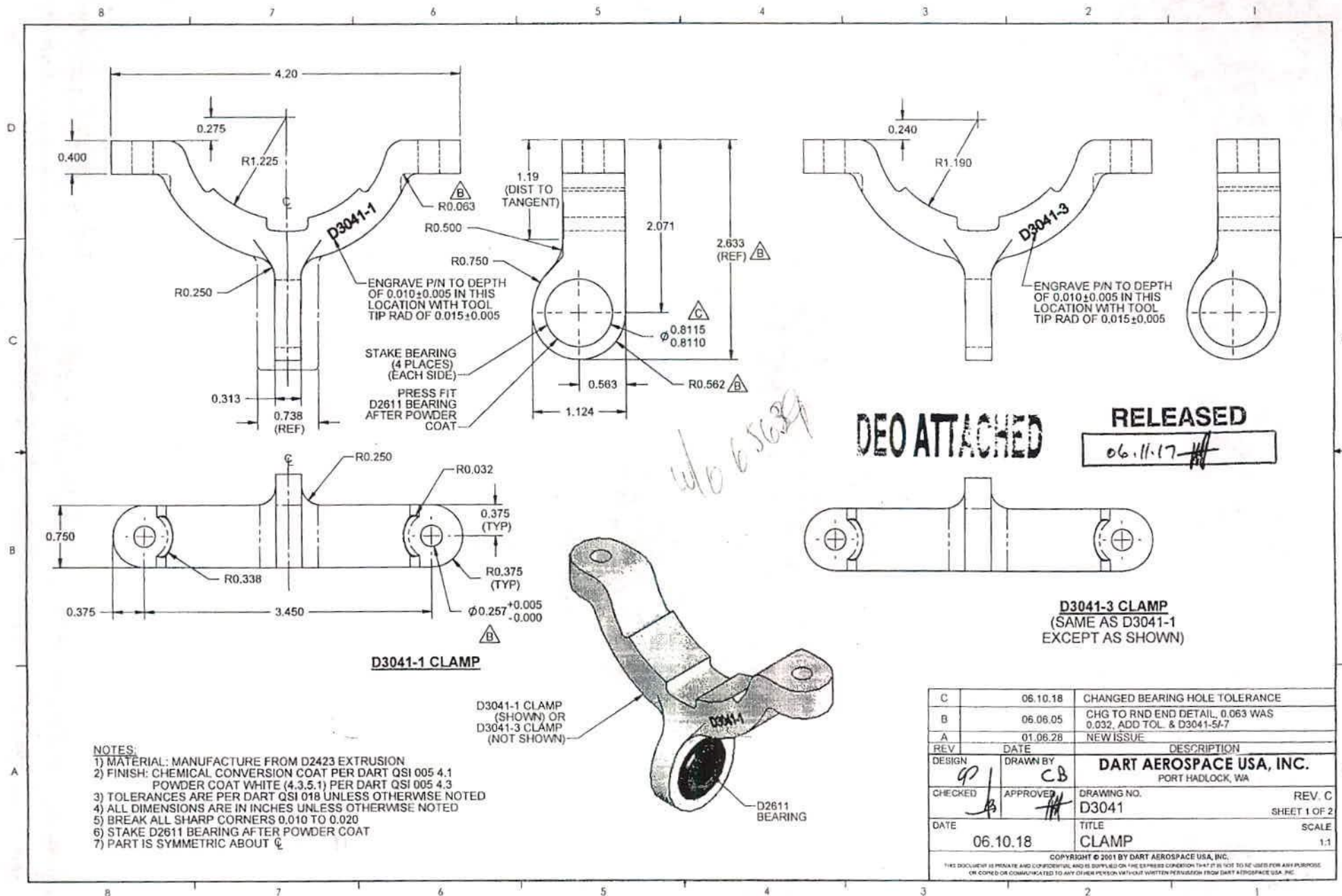
20

B65640 (12)

D 3041-3P

X20

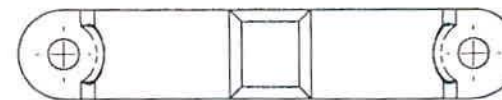
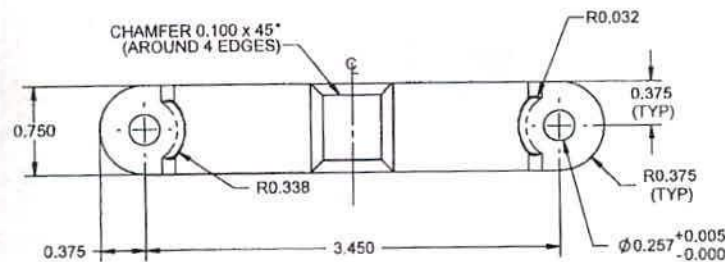
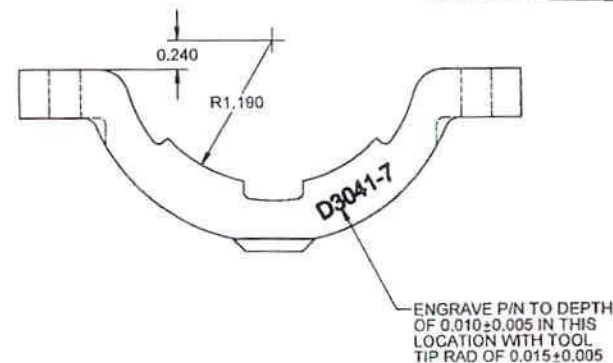
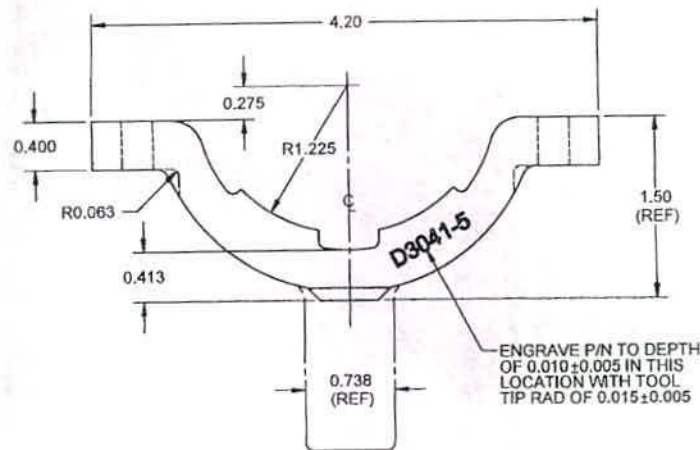
1/4/13 (12)



DEO ATTACHE

RELEASED

dc.11.17 #

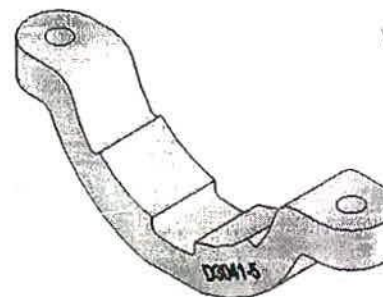


D3041-5 CLAMP

D3041-7 CLAMP
(SAME AS D3041-5
EXCEPT AS SHOWN)

NOTES:

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
- 6) PART IS SYMMETRIC ABOUT ϕ

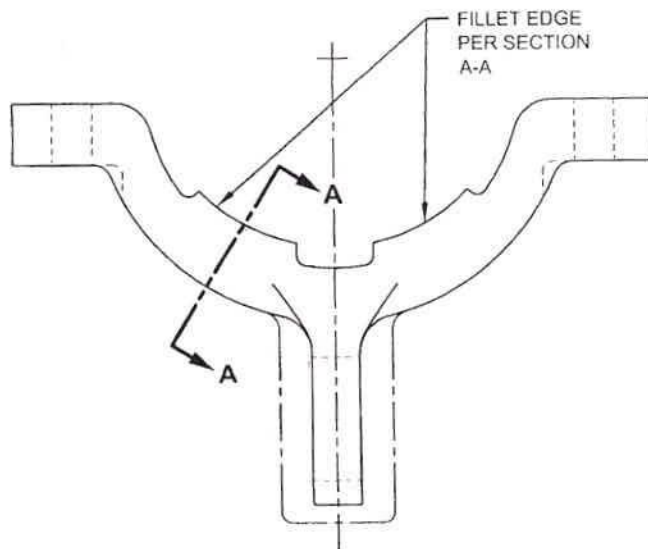


DESIGN 	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3041	REV. C
DATE 06.10.18	TITLE CLAMP	SHEET 2 OF 2	
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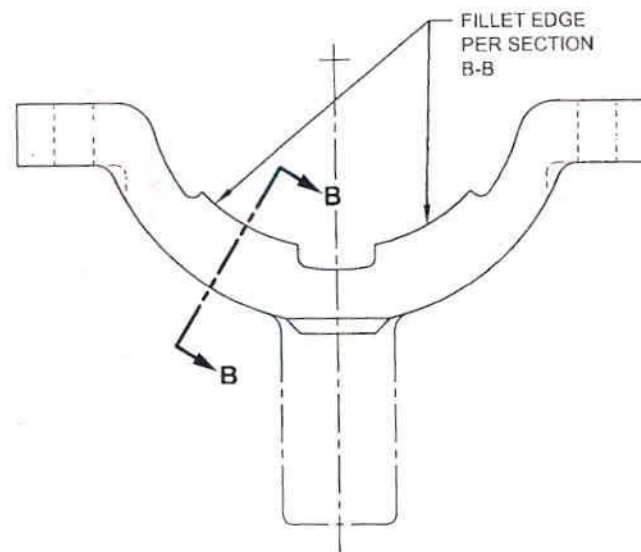
DRAWING NO. D3041	TITLE CLAMP	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3041-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN ADS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 09.03.04	DATE 09.03.12	DATE 09.03.12	DATE 09.03.13		DATE 09.03.13		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



D3041-1 CLAMP

D3041-3 CLAMP



D3041-5 CLAMP

D3041-7 CLAMP



R0.060 MIN - R0.10 MAX
2PL

SECTION A-A

SCALE 2X

SECTION B-B

SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

RELEASED
09/07/07

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DART AEROSPACE LTD		Work Order: 65039
Description: Clamp		Part Number: D3041-3
Inspection Dwg: D3041	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	+/-0.030					
0.240	+/-0.010					
R1.190	+/-0.010					
0.400	+/-0.010					
R0.250	+/-0.010					
0.313	+/-0.010					
R0.063	+/-0.010					
1.19	+/-0.030					
1.124	+/-0.010					
0.563	+/-0.010					
R0.562	+/-0.010					
Ø0.8115 - 0.8110	N/A					
2.071	+/-0.010					
0.750	+/-0.010					
0.375	+/-0.010					
R0.338	+/-0.010					
3.450	+/-0.010					
Ø0.257	+0.005-0.000					
R0.375	+/-0.010					
0.375	+/-0.010					
R0.032	+/-0.010					
R0.250	+/-0.010					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17816

Date: Mar 09, 2011

Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13326	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-3 Crosstube Lug Material supplied by DART: D2423 B45800	Each	30		
D3910-1 Crosstube Lug Material supplied by DART: D2423 B	Each	30		
D4091-1 Lug Material supplied by DART: D2423 B	Each	24		
D3041-1 Clamp Material supplied by DART: D2423 B63005	Each	20	20	
D3041-3 Clamp Material supplied by DART: D2423 B63005	Each	20	12	
Received by _____		Thank you for your order!		

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

12

D3041-3

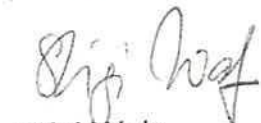
Clamp

13326

MATERIAL: supplied by DART D2423 B63005

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Shigi Walz

Vankleek Hill, March 9, 2011